

*SPUT*  
**Work Order ID 61881-1**

**PREL**



Page 1

Wednesday, September 08, 2010 3:27:17 PM

Item ID: D4174-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Connector Plate

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *M*

Date: *10-9-05*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4174

PA1

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *PA1*

Prog Rev: *PA1*

2-Deburr if necessary

*B10-9-13*

*(4)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B10-9-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 61881

Wednesday, September 08, 2010 3:27:17 PM



Page 2

Item ID: D4174-1 Accept

Revision ID: PRELIM

Item Name: Connector Plate

Start Date: 9/8/2010 Start Qty: 3.00

Required Date: 9/13/2010 Req'd Qty: 3.00

Reference:



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 - 5/10/04/13 0.00 inspected to PA1 Dry only (K4)							
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 BR 10-9-14. 0.00				(4)	φ		
140  Powdercoat Powder Coating	White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum  Memo Start Time: 1:50 Oven Temperature: 320° Finish Time: 2:20	0.00 BR 10-9-16 0.00				(4)	φ		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 61881

Wednesday, September 08, 2010 3:27:17 PM



Page 3

Item ID: D4174-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Connector Plate

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00

⇒ M 10/09/10

XV

0



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: CA

0.00



Packaging

Memo

0.00

Iron

BS 10-09-23<sup>①</sup>

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/29  
10.09.23

POSITIVE RECALL

EFFECTIVE 10.09.09

AUTH

h

RELEASED

DATE

10.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 08, 2010 3:27:21 PM

Page 1

Work Order ID: 61881



Parent Item: D4174-1



Parent Item Name: Connector Plate



Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	104.9340	0.11	0.347368	145		
6061-T6 .063 Sheet												1310-9-13	

Location

Loc Qty

Loc Code

MAT21

104.934

113608

104.934

113608

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

LOVE



41881  
p10-9-09

759  
1,062  
938

0.063  
REF

PRELIMINARY ISSUE  
10.09.08

1) MATERIAL: 6061-T6/1762 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: PER QSI 044 6.1

7) WEIGHT: 0.08 lbs

PA1	NEW ISSUE		MB	10.09.01
REV.		DESCRIPTION	BY	DATE
DESIGN	1	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4174</b>  TITLE <b>CONNECTOR PLATE</b>  COPYRIGHT © 2016 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS TO BE USED FOR IDENTIFICATION PURPOSES ONLY. IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>		
DRAWN	1			
CHECKED				
MFG. APPR.				REV. PA1
APPROVED				SHEET 1 OF 2
DE APPR.				SCALE
DATE	10.09.01			NTS

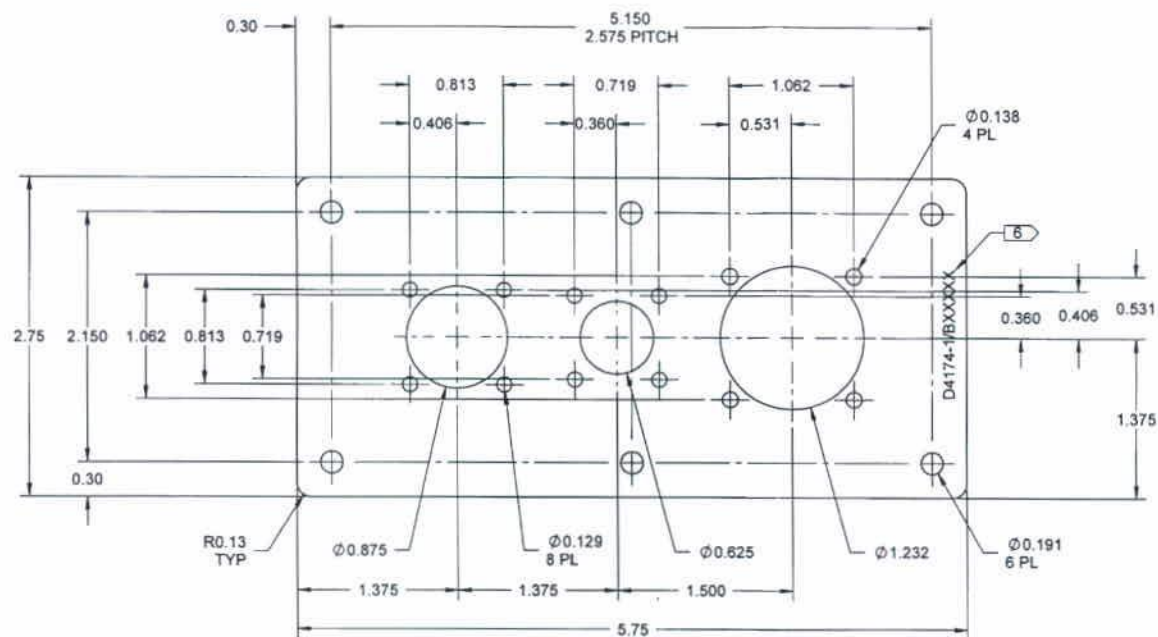
DART AEROSPACE LTD		Work Order: 61881
Description: CONNECTOR		Part Number: D4174-1
Inspection Dwg: D4174-1 Rev: PA1		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	*		V HB02	
Ø .138	+ .005 - .001	.139	*		V	
Ø .191	+ .005 - .001	.191	*		V	
Ø .625	+ .008 - .001	.626	*		V	
Ø .875	+ .010 - .001	.875	*		V	
Ø 1.232	+ .012 - .001	1.232	*		V	
.30	± .030	.300	*		V	
5.150	± .010	5.149	*		V	
2.575	± .010	2.574	*		V	
.813	± .010	.810	*		V	
.719	± .010	.717	*		V	
1.062	± .010	1.062	*		V	
.406	± .010	.404	*		V	
.366	± .010	.360	*		V	
.531	± .010	.532	*		V	
1.375	± .010	1.375	*		V	
1.500	± .010	1.500	*		V	
5.75	± .030	5.747	*		V	
2.150	± .010	2.146	*		V	
2.75	± .030	2.749	*		V	
.063	± .010	.060	*		V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-9-13	Date: 10/09/13	Date:	N/A
inspected to PA1 Dwg only		Revised by	Approved
Rev	Date	Change	
A		New Issue	KJ/JLM



**D4174-1 CONNECTOR PLATE**

**NOTES:**

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
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REV.		DESCRIPTION		BY	DATE
DESIGN	1	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	1				
CHECKED	1				
MFG. APPR.	1				
APPROVED	1	DRAWING NO. <b>D4174</b>		REV. A	SHEET 1 OF 2
DE APPR.	1	TITLE <b>CONNECTOR PLATE</b>		SCALE	NTS
DATE	10.09.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

**RELEASED**  
2010-09-29